

Work Order ID 58226

April 29, 2010 1:07:22 PM



Page 1

Item ID: D412-742-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 4/29/10

Start Qty: 1.00



Cust Item ID:

Required Date: 5/03/10

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-742

D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D412-742-013 CHG006

8 10/5/10

HA for BG 10/04/29

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

B38226

10-5-35

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

8 10/5/10

@

Work Order ID 58226

April 29, 2010 1:07:22 PM

Page 2

Item ID: D412-742-013

Accept

Revision ID:

Item Name: Float Skidtube Installation

Start Date: 4/29/10 Start Qty: 1.00

Required Date: 5/03/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-013

Location: 14 H

140

0.00



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

*Rec'd 5/3**10/05/05**LC 000504*

Picklist Print

April 29, 2010 1:06:54 PM

Page 1

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A 105.10.13 New Issue: KJ/JLM
IPP Rev: B 06-06-08 As per DSI9336 JLM IPP Rev: C 07-12-03 ECN 1072 DD verified by: JLM
IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

AN4C7A : Purchased No 110 Each 492.0000



Bolt

Location Loc Qty Loc Code

ST356 492

109147 492

D412-742-043 Manufactured No 110 Each 0.0000



Replacement Float Skidtube

D2571 Manufactured No 110 Each 16.0000



Saddle, Fwd Out 205

Location Loc Qty Loc Code

ST425 8

43564 4

47564 4

ST433 8

57616 8

D2572 Manufactured No 110 Each 10.0000



Saddle, Fwd In 205

Location Loc Qty Loc Code

ST425 4

43565 4

ST433 6

57617 6

Picklist Print

April 29, 2010 1:06:55 PM

Page 2

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A :05.10.13 New Issue: I KJ/JLM:
IPP Rev:B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by:JLM
IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

D2573

Manufactured No

110

Each

19.0000



Saddle, Aft Out 205

Location

Loc Qty

Loc Code

ST425

11

43566

4

47566

4

52911

3

ST434

8

57630

8

D2574

Manufactured No

110

Each

15.0000



Saddle, Aft In 205

Location

Loc Qty

Loc Code

ST425

7

43567

4

56398

3

ST434

8

57631

8

D2876

Manufactured No

110

Each

115.0000



Saddle Spacer

Location

Loc Qty

Loc Code

ST028

115

42364

68

51540

47

April 29, 2010 1:06:55 PM

Shop Packet Print

Page 2

Picklist Print

April 29, 2010 1:06:55 PM

Page 3

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A (05.10.13) [New Issue] KJ/JLM
IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD verified by: JLM
IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

D2877

Saddle Spacer

Manufactured No 110 Each 47.0000



Location Loc Qty Loc Code

ST028 47
47292 10
51541 37

47292

D3403-1

Bushing


Manufactured No 110 Each 92.0000



Location Loc Qty Loc Code

ST055 92
56856 92

56856

D2747

Set Screw

Manufactured No 110 Each 157.0000



Location Loc Qty Loc Code

ST023 157
39224 4
51921 153

51921

D3533-1

Set Screw

Manufactured No 110 Each 145.0000



Location Loc Qty Loc Code

ST069 145
51602 145

51602

April 29, 2010 1:06:55 PM

Shop Packet Print

Page 3

Picklist Print

April 29, 2010 1:06:55 PM

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/29/10

Required Date: 5/03/10

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM:
 IPP Rev: B 06-06-08 As per DS19336 JLM IPP Rev: C 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

AN4C6A Purchased No 110 Each 507.0000 16



Bolt

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	503	
112794	3	
113121	500	

AN4C52A Purchased No 110 Each 142.0000 8



BOLT

Location	Loc Qty	Loc Code
ST361	142	
112641	50	
113121	92	

AN6C12A Purchased No 110 Each 120.0000 8



BOLT

Location	Loc Qty	Loc Code
ST342	120	
110396	70	
114442	50	

Picklist Print

April 29, 2010 1:06:56 PM

Page 5

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A 105.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP Rev C 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

D3672-3

 Phenolic Washer

Manufactured No

110

Each

1,384.000

32

Location

Loc Qty

Loc Code

ST077

1384

51596

6

55560

378

57704

1000

55560

AN960C416L

 WASHER

Purchased

No

110

Each

1,192.000

32

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

1148

112612

248


112794

500

112828

400

1112612

D3672-9

 Phenolic Washer

Manufactured

No

110

Each

462.0000

8

Location

Loc Qty

Loc Code

ST077

462

35523

462

35523

April 29, 2010 1:06:56 PM

Shop Packet Print

Page 5

Picklist Print

April 29, 2010 1:07:04 PM

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/29/10

Required Date: 5/03/10

Comments: IPP Rev: A: 05.10.13 New Issue: KJ/JLM
 IPP Rev: B 06-06-08 As per DS19336 JLM IPP RevC 07-12-03 ECN
 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C616L

Purchased No

110 Each

228.0000

8



WASHER

Location

Loc Qty

Loc Code

ST347

228

111424

28

113064

200

M111429

D3672-11

Manufactured No

110 Each

1,000.000

16



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

1000

58046

1000

58046

MS21043-4

Purchased No

110 Each

1,569.000

29



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1529

112492

58

113064

31

113069

40

114181

400

114348

500

114523

500

M113064 24

Picklist Print

April 29, 2010 1:07:04 PM

Page 7

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM
IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by: JLM
IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

D3403-3 Manufactured No 110 Each 69.0000



Bushing

Location Loc Qty Loc Code

ST055 69

56857 69

D3405-041 Manufactured No 110 Each 9.0000



Lug Assembly

Location Loc Qty Loc Code

ST474 9

53887 1

56835 8

D3405-043 Manufactured No 110 Each 15.0000



Lug Assembly

Location Loc Qty Loc Code

ST474 15

53888 1

56574 14

AN4C47A Purchased No 110 Each 29.0000



Bolt

Location Loc Qty Loc Code

ST361 29

113302 29

April 29, 2010 1:07:04 PM

Shop Packet Print

Page 7

Picklist Print

April 29, 2010 1:07:10 PM

Page 8

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DS19336 JLM IPP Rev: C 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

D3407-041 Manufactured No 110 Each 12.0000



Tow Ring



57950

[Handwritten signature]

Location	Loc Qty	Loc Code
ST464	12	

57950

D3417-3 Manufactured No 110 Each 126.0000



Washer



2

[Handwritten signature]

Location	Loc Qty	Loc Code
ST056	126	
44349	45	
51648	28	
53182	53	

44349

D3456-1 Manufactured No 110 Each 150.0000



Washer



5

[Handwritten signature]

Location	Loc Qty	Loc Code
ST058	150	
51653	16	
54692	134	

51653

AN3C37A Purchased No 110 Each 60.0000



BOLT



1

[Handwritten signature]

Location	Loc Qty	Loc Code
ST353	60	
112454	60	

112454

April 29, 2010 1:07:10 PM

Shop Packet Print

Page 8

Picklist Print

April 29, 2010 1:07:10 PM

Page 9

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A 05.10.13 New Issue 1 KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

AN3C40A Purchased No 110 Each 127.0000



BOLT

Location Loc Qty Loc Code

ST354 127
 106176 27
 112454 50
 114442 50

M106176

*AN3C41A Purchased No 110 Each 225.0000



BOLT

Location Loc Qty Loc Code

FG 4
 103324 4
 ST354 221
 112431 21
 112829 100
 114443 100

M112431

AN3C42A Purchased No 110 Each 126.0000



BOLT

Location Loc Qty Loc Code

ST354 126
 106169 26
 106176 100

M106169

April 29, 2010 1:07:10 PM

Shop Packet Print

Page 9

Picklist Print

Page 10

April 29, 2010 1:07:16 PM

Work Order ID: 58226

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A | 05.10.13 | New Issue | KJ/JLM |
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 4/29/10

Required Date: 5/03/10

Start Qty: 1.00

Required Qty: 1.00

AN3C43A



BOLT

Purchased No 110 Each 149.0000



4

Location Loc Qty Loc Code

ST354 149

114330 49

114433 50

114455 50

M114330

AN3C46A



BOLT

Purchased No 110 Each 56.0000



5

Location Loc Qty Loc Code

ST355 56

113164 13

113302 43

AN960C10L NAB1149C0332R



washer

Purchased No 110 Each 0.0000



26

MS21043-3



Nut

Purchased No 110 Each 3,761.000



13

Location Loc Qty Loc Code

FG 80

103691 80

ST301 3681

112314 3681

M112314

April 29, 2010 1:07:16 PM

Shop Packet Print

Page 10

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D412-742

Page 18 of 20

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

• COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: D

Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D412-742

Page 19 of 20

(CONTINUED FROM PAGE 18)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

• COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: D
Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37
REF. EASA STC: EASA.IM.R.S.01126

REFERENCE ONLY

INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List 32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
----	---	--	--	---------	------

WAS:

63	4			AN4C46A	BOLT
----	---	--	--	---------	------

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List 32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4			AN4C47A	BOLT
----	---	--	--	---------	------

WAS:

63	4			AN4C46A	BOLT
----	---	--	--	---------	------

A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.	W	BOLT CHANGE	NTS
DATE	08.12.19	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* **NOTE:** Date & initial all entries